120

QC4-100% Inspect kits for completeness

0.00

0.00

Packaging

Packaging

QC

Memo

Memo

0.00

Quality Control



				DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date	:	
Work Orde	er.					DISPOSITION							
Part No. Scrap Use-as-is NCR No. Work Order Update Machining Sm Thermoforming Fin Large Fab Com							Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root					Descri	ption of work order update	Initia	1 A	Action	Sign &			
Cause	l	Date	Step	Qty		or Non-conformance	Chief E	1	scription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training							v						
Unapproved	<u> </u>	<u></u>	l	L	<u> </u>		L ΔULT CA	I ATEGORY			<u> </u>		
Landi	ng Ge	ar				General	AOLI CA						
	B C C C C C C C C T R Ir	ending entre No racks rushed/o uffs leat Trea nspection ipples in orque W	Crimped. It In Strip in Bend	Contamination Countersink trip in Tube Cut Too Short Drill Holes es in Extrusion Drawing				in dware ection Incomplete ructions Incomplete intenance abeled read et of Calibration of Sequence	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
Wave/Twist in Tube Folio Outside Dimensions													

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

89910

Page 2

September-12-11	2 1:06:10 PW	1 <u>-</u> .							
Item ID: Revision ID:	D350-567-11	5		Accept	*N9000401	೧ ೧*	Setup	Start	*NS1*
Item Name:	Interior Floor	Window						Stop	*NS2*
Start Date: Required Date: Reference:	12/09/2012 10/10/2012	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:				14.77
Approvals:	Process Pla	n:	Date:	Tooling:	Date:		Run	Start	*NR1*
	QC:			_ SPC (Y/N):	Date:			Stop	*NR2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID Tool # Pla	an Accep ode Qty	ot Rej Qty		Reject Insp. Number Stamp
130 Packaging		Packaging Memo		0.00	PPP89909	d			9256/plc
Packaging				PPP D350-567-115	• •				,
140		QC21- Final Inspection -	- Work Order Release	0.00				12	La bud
140 ^{QC}		Мето		0.00		-		<i> </i>	10 p4

112-10-24

												DQA:	Da ⁻	te:	
NCR:	Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:									
											(QA Closed:	Da	te:	
Work Ord	۰					DISPOSITION				AGAINST DI	ĘΡ	ARTMENT/	PROCESS	₽,	•
WOLK Ord	er.					Rework	7		Skid-tube	Crosstube	٦		Wafer Jet		Engineering
Part I	No.					Scrap	1	i .	Machining	Small Fab	┪	Proc	d. Eng. Coor.		Quality
raili	VO.					Use-as-is	1	1	noforming	Finishing	┨		e/Packaging		Other
NCR I	۷n					Work Order Update	1		Large Fab	Composite	1	1100,0101	Supplier	-	
i i i i i i i i i i i i i i i i i i i	•0.					Work Order opace			20.80 . 00				55		
Root			·		Descri	ption of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Descr	iption		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling											۱				, . ,
Operator							1								
Material			l		•										
Setup															
Other			ĺ												
Process							1								
Supplier															1
Training											1				
Unapproved	L												<u></u>		
							AUI	LT CATE	GORY						
Landi	ng (1				General	_	1		<u></u>	_			_	1
	<u> </u>	Bending			ļ	Bend	\vdash	Grain		-	┥.	Ovalized		ļ	Pressure/Forced
Centre Not Concentric to O/S					o/s	BOM/Route	\vdash	Hardwa		<u> </u>	-	Over/Under			Temperature/Cure
Cracks						Broken/Damaged	_	- i	on Incomplete	<u> </u>		Part Incorred		_	Weld
					<u> </u>	Burrs	\vdash	4	ions Incomplete/U	Jnclear	_	Part Lost/Mi	ssing		Wrong Stock Pulled
	<u> </u>	Cuffs			ļ	Contamination	<u> </u>	Mainte			⊣	Part Moved			
	$oxed{\!$	Heat Trea			ļ	Countersink		Mislabe		_		Positioned V	-		7
Inspection Strip in Tube						Cut Too Short Misread Po					Power Loss/	Surge	L	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

September-12-12 1:06:14 PM

Work Order ID: 89910

D350-567-115

Parent Item Name: Interior Floor Window

89910

D350-567-115

Start Date: 12/09/2012

Required Date: 10/10/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

Parent Item:

IPP Rev:A New Issue 04-08-24 JLM

IPP Rev:B CHG#2 ECN 1055 07-11-21 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C632R12 *AN526C66 Screw	39R19	Purchased	No			110	Each	205.0000	**	36		SL	_
		t		Location	<u>!</u>	Loc	<u>Oty</u>	Loc Code					
				ST344			100				_	com.	4
				Ç	122378		100			29	_	SX	∞
				ST345	122214		100			<u>.</u>	=		
				ST24C	122814		100		_	_+	-		
				ST346	121556		4 1				-		
				ST347	121000		1		_		_		
					119225		1		_		-		
D2463		Manufactured	No			110	f	407.9974	AAD 1	17.64	_		
*D24636									**			8	
				Location		Loc (<u>Qty</u>	Loc Code					
				ST404		407.99	9737		_		_		/
	7 .00				72232		5.38		_		_	57	nt Pl
	The Astre)	!			79478 83542		3737 2.18				- /		- 0

1X (d2463-0530 AS PER DWG) CUT TO 53.00"

										DQA:	Date:	
NCR:	res / No				WORK ORDER NON-C	CON	NFORM	MANCE / UPDAT		QA Closed:	Date:	
					DISPOSITION	I			AGAINST DEP			•
Work Orde	er:					,						
Part f					Rework Scrap Use-as-is Work Order Update			Machining S noforming	rosstube mall Fab Finishing mposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering • Quality Other
Root				Descri	ption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descriptio	on	Date	Verification	QC Inspector
Doc/Data					•							
Equip/Tooling												
Operator												
Material										,		
Setup		1										
Other		1										
Process						l						
Supplier												
Training												
Unapproved	l . l			1		<u> </u>	T 6475	<u> </u>			L	<u> </u>
						AUL	T CATE	GORY		<u> </u>		
Landi	ng Gear				General		ارسن			Ovalized		Pressure/Forced
	Bending			_	Bend	\vdash	Grain		——		+-laranaa	Temperature/Cure
	-	lot Conce	ntric to	^{0/5} -	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under	<u> </u>	Weld
	Cracks	(C			Broken/Damaged	\vdash	1	ion Incomplete		Part Incorre		Wrong Stock Pulled
		/Crimped	-	<u> </u>	Burrs	\vdash	4	tions Incomplete/Uncle	—	Part Lost/M		Tantonia prock Lanea
	Cuffs	-4		-	Countaries	\vdash	Mainte		ļi	Part Moved		
	Heat Tre	:at		1	Countersink	1	Mislabe	eieu	1 1	Positioned \	wrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Picklist Print

September-12-12 1:06:14 PM

Work Order ID: 89910

89910

Parent Item:

D350-567-115

D350-567-115

Parent Item Name: Interior Floor Window

Start Date: 12/09/2012

Required Date: 10/10/2012

Start Qty: 4.00

Required Oty: 4.00



Manufactured

110

21.0000

Each

SmD

1	Bodolei			

Manufactured

Location Loc Oty ST211 21 84073 3 6 12 110 Each

11.0000

Loc Code



D3294-1

~	D3295-041	
	ED3795=0215 Floor Window	*

Manufactured

Location Loc Qty ST212 64793 84071 86698 110 23.0000 Each

Loc Code

5m1>

Location

ST212 110 Loc Qty 12 Each

Loc Code

D3296-041

Manufactured No 8.0000

**

1488286//

Door Assembly

Location ST218

Loc Qty 8 Loc Code

4												DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	/ANCE / UPI	DATE		_			
:												QA Closed:	Date	<u>;</u>	
Work Orde	or.					DISPOSITION				AGAINST D	EF	ARTMENT/	PROCESS		•
VVOIR OIG	٠٠.			· · ·		Rework			Skid-tube	Crosstube	٦		Water Jet		Engineering
Part I	No.					Scrap		1	Machining	Small Fab	٦	Prod	d. Eng. Coor.	٦	Quality
	•					Use-as-is		4	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	No.					Work Order Update]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update	Π	Initial	Act	ion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription	╛	Date	Verification		QC Inspector
Doc/Data	Ш													Ì	
Equip/Tooling							l							- [
Operator	Ш		1												
Material	Ш								i					- 1	
Setup															
Other															
Process	Ш														
Supplier	Щ									•					
Training	Ш														
Unapproved	Ш		<u> </u>	<u> </u>		· · · · · · · · · · · · · · · · · · ·	<u> </u>				J			لـــ	
							AUI	LT CATE	GORY						
Landi		ì				General		اد د د		Г	_	ا د تا ما	Г	_	B
	\vdash	Bending				Bend	<u> </u>	Grain		<u> </u>	-	Ovalized		_	Pressure/Forced
	-	Centre No	ot Concei	ntric to	^{0/S} -	BOM/Route	-	Hardwa		 	_	Over/Under	-		Temperature/Cure
	-	Cracks	o :		<u> </u>	Broken/Damaged	-	⊣ `	on Incomplete	-	_	Part Incorred	<u> </u>	\dashv	Weld
	\vdash	Crushed/	crimped.	•	-	Burrs	-	4	ions Incomplete/	Unciear	_	Part Lost/Mi	ssing		Wrong Stock Pulled
	-	Cuffs			-	Contamination	-	Mainte		-		Part Moved	Managa		
	\vdash	Heat Trea		Tulka	-	Countersink	\vdash	Mislabe		-	_	Positioned V			Othan
	\vdash	Inspectio		rube	ļ	Cut Too Short	\vdash	Misread	1	L		Power Loss/	ourge [Other
Ī	1 1	Ripples in	Bena			Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-12-12 1:06:15 PM

Work Order ID: 89910

Parent Item:

D350-567-115

Parent Item Name: Interior Floor Window

MS20470AD4-5

MS20470AD4-6

Purchased

No

89910

D350-567-115

110

Each

2,262.000

Loc Code

**

Start Qty: 4.00

Start Date: 12/09/2012

Required Qty: 4.00

Required Date: 10/10/2012

Purchased No Location Loc Oty 334 1410 122452 1410 ST319 852 118405 317 535 110 Each

3,040.000 **

5m/2

Rivet, Universal Head

Location	Loc Qty	Loc Code	
336	1500		_
122452	1500		19
ST319	1540		
117395	16		
118927	157		
119109	12		
120142	81		

1274

												DQA:	Da	ite:	
NCR:	/es	/ No				WORK ORDER NON-C	10:	NFORM	ANCE / UPD	ATE		<u>-</u>		•	
											QA	Closed:	Da	te:	
Work Orde	or.					DISPOSITION				AGAINST DE	PAR	TMENT/	PROCESS		ŧ
Work Orac						Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap		ſ	Machining	Small Fab		Proc	d. Eng. Coor.		Quality
	•					Use-as-is			noforming	Finishing	F	Rec/Stor	re/Packaging		Other
NCR N	۱о.					Work Order Update Large Fab Composite							Supplier	Ш	
Root					Descri	ption of work order update	П	nitial	Actio	on	Si	ign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	'n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material															<u> </u>
Setup						•									
Other									•						
Process							l								
Supplier															
Training						•					•				
Unapproved			<u> </u>	<u> </u>											
		·- ·- ·				F	AUL	T CATE	GORY						
Landi	ng G	Gear			_	General				,	,			_	1
		Bending				Bend		Grain			4	ilized		\perp	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	Hardware				Ove	er/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged Inspection Incomplete					Par	t Incorrec	ct	\perp	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/U	nclear	Par	t Lost/Mi	ssing	L	Wrong Stock Pulled
	Cuffs Contamination Maintenance						Par	t Moved							
		Heat Trea	it			Countersink		Mislabe	led		Positioned Wrong				
		Inspection	n Strip in	Tube		Cut Too Short	Misread					ver Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

September-12-12 1:06:15 PM

Work Order ID: 89910 *89910* Parent Item: D350-567-115 *D350-567-115* Parent Item Name: Interior Floor Window **Start Date:** 12/09/2012 **Required Date: 10/10/2012** Start Qty: 4.00 Required Oty: 4.00 MS20470AD4-7 Purchased No 110 Each 2,001.000 60 ** Location Loc Qty Loc Code 336 1300 122452 1300 SMY ST139 384 121415 384 ST319 52 120769 52 ST320 265 116081 117 118614 148 MS21042L06 Purchased No 110 Each 547.0000 36 ** \mathfrak{A} Location Loc Qty Loc Code 315 280 122441 280 Smy ST300 67 121556 67 ST317 200 122151 200 NAS1149DN632J Purchased No 110 294.0000 Each ** Location Loc Qty Loc Code 298 200 122441 200 ST298 94

94

118428

NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:												
											QA Closed:	Date	:
Work Ord	er: ˌ					DISPOSITION					PARTMENT	_	,
Part I	•				 -	Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining Moforming Marge Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering ' Quality Other
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		Initial nief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							- A 1 11	LT CATE	GORY				
Landi	ing (Gear				General	70.	- Critic	30.11				
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend						Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		-1	ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1	Torque M	Javes in F	vtrusion		Drawing	-	Dut of (Calibration				

Out of Sequence
Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

REFERENCE ONLY 3mb

DART AEROSPACE LTD.

D350-567 Page 28 of 28

PARTS LIST 5.0

Qty	Qty	Qty	Qty	Qty	Qty		
-015	-017	-025	-027	-111_	-117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	Х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
	<u> </u>			X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					1		
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT
l					<u> </u>		(SLIDING DOOR COMPATABLE)

Qty	Qty	Qty	-Qty_	Qty		
-013	-023	-113	-115	-031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	Х				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				Х	D350-567-031	INTERIOR FLOOR WINDOW KIT
						(SLIDING DOOR COMPATABLE)
					D2125	REPLACEMENT WINDOW, SMALL
11					D2942	REPLACEMENT WINDOW, LARGE
	1				D3290-041	REPLACEMENT WINDOW, BANGE REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
		1			D3290-041	REPLACEIVIENT WINDOW ASSEMBLT, EXTIN EARGE
. 1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1	İ		D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12	1		2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21	· · · · · · · ·		AN526C832R9	SCREW (OR AN526C832-9,OR MS51957-126)
	44	42	<u> </u>		AN960JD8	WASHER
	22	21	<u> </u>		MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ.	2 SQ.	2 SQ.			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
YD	YD	YD				
····			1	1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
			-	1	D3213-041	DOOR ASSEMBLY
			<u>_</u>		±D3293-1	=DOUBLER>
			r-10		-D3294=1> (BRACKET-
	 				-D3295-041	-FLOOR:WINDOW-)
	<u> </u>		113		(D3296-041)	DOOR ASSEMBLY\
			1		D2463-0530	NEOPRENE SEAL
			<u>دو</u> ر	8	AN526C632R12_	-SCREW:(OR AN526C632=12; OR MS51957=32)
			1 9.	8	AN960JD6	_WASHER~;
			9)	8	MS21042L06	NUT (OR MS21042-06)
<u> </u>			1 2/	40	MS20470AD4-5-	-RIVET
			1457	90 •	MS20470AD4=6	TRIVET-
	<u> </u>	· ·	15-	حر 20	_MS20470AD4-7	_RIVET)
	<u> </u>		N. M. Strate	-		

COPYRIGHT © 2000 BY DART AEROSPACE LTD ●

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D

Date: 08.07.08